

Date: Thursday, 11/12/2008 10:35:04 AM
 User: Melanie Fauteux

Process Sheet











Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT DOUBLER
Job Number : 05067	
Estimate Number : 13151	
P.O. Number :	Part Number : D37035
This Issue : 11/12/2008 S.O. No. :	Drawing Number : D3703 PROTOTYPE 108.12.16
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : SMALL /MED FAB	Drawing Revision : PRELIM
Previous Run : 5000	Material :
Written By :	Due Date : 12/12/2008 Qty: <u>3</u> Um: Each
Checked & Approved By : <u>MFC 08-12-11</u>	
Comment : Est Rev:A 08-04-24 new issue DD verified by:EC	

Additional Product

PRELIMINARY ISSUE

Job Number:

**PROTOTYPE**

Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6S063	6061-T6 .063 Sheet
  <p>Comment: Qty.: 0.0833 sf(s)/Unit Total: 0.0833 sf(s) 6061T6 aluminium sheet .063" thick (M6061T6S063) Batch: <u>108279</u> <u>IB 9-1-6</u></p>		
2.0	WATER JET	FLOW WATER JET
  <p>Comment: FLOW WATER JET 1-Cut as per Dwg D3703 Dwg Rev: <u>PRELIM</u> <u>IB 9-1-6</u> Prog Rev: <u>PRELIM</u> 2- Deburr if necessary <u>IB 9-1-6</u></p>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
  <p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>IB 9-1-6</u></p>		
4.0	QC8	SECOND CHECK
  <p>Comment: SECOND CHECK <u>ENG. PEERING APPROVAL</u> <u>109.01.21</u> <u>3x</u></p>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
  <p>Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>SL 9-1-24</u> <u>3</u></p>		

Date: Thursday, 11/12/2008 10:35:05 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOUBLER

Job Number: 05067

Part Number: D37035

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-26

43

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

51182

SS 09/01/26

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



pull on,

60224A

POSITIVE RECALL

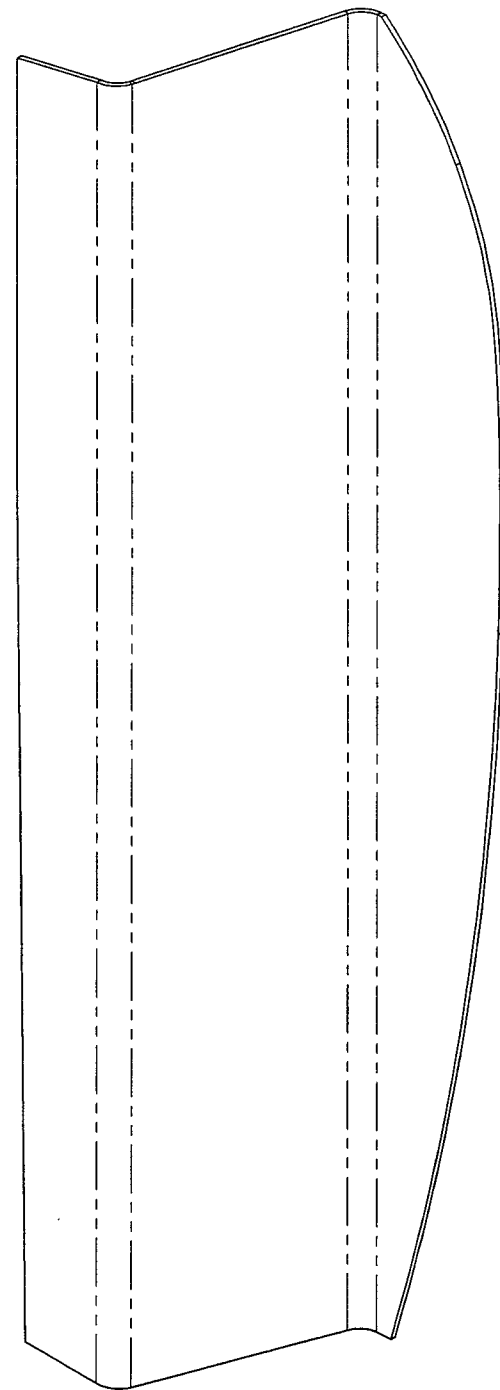
EFFECTIVE

09.15.26

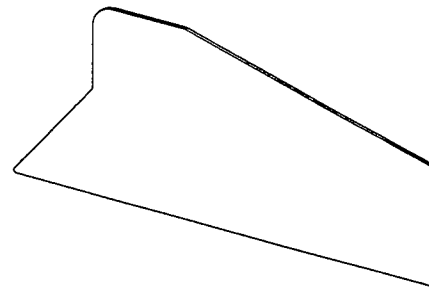
RELEASED

DATE

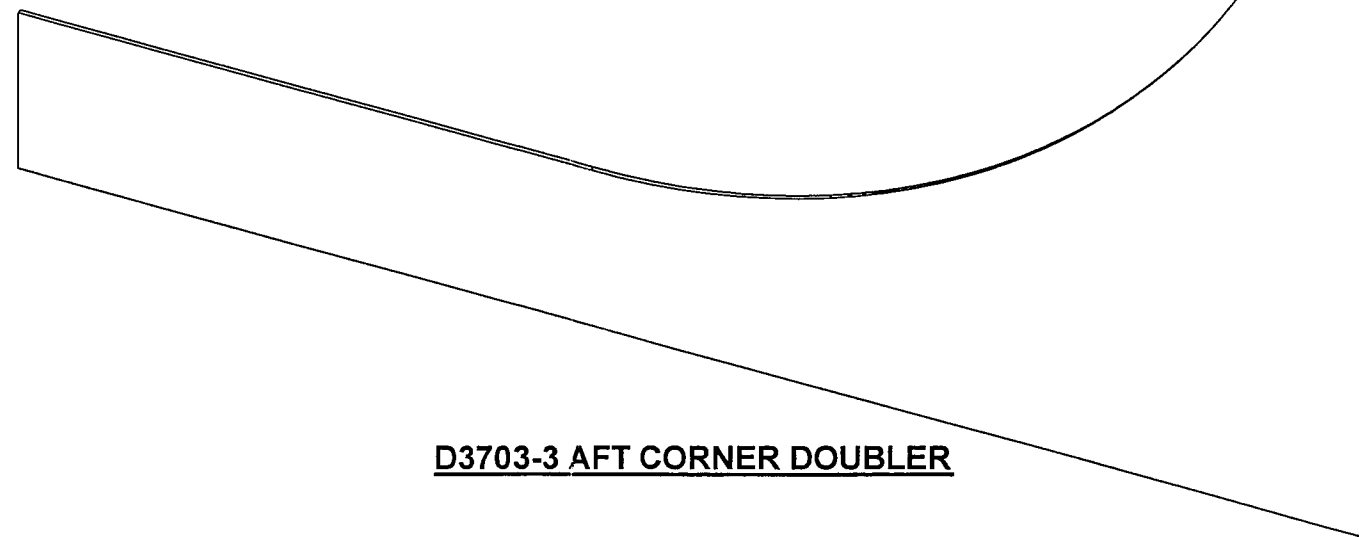
04.05.26



8 D3703-1 AFT DOUBLER



D3703-5 AFT CAP



D3703-3 AFT CORNER DOUBLER

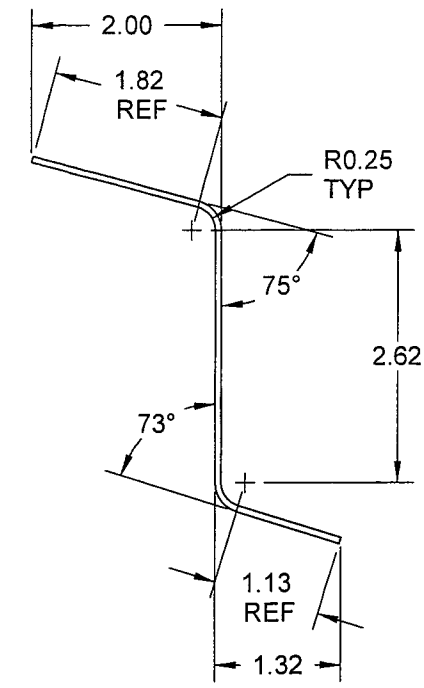
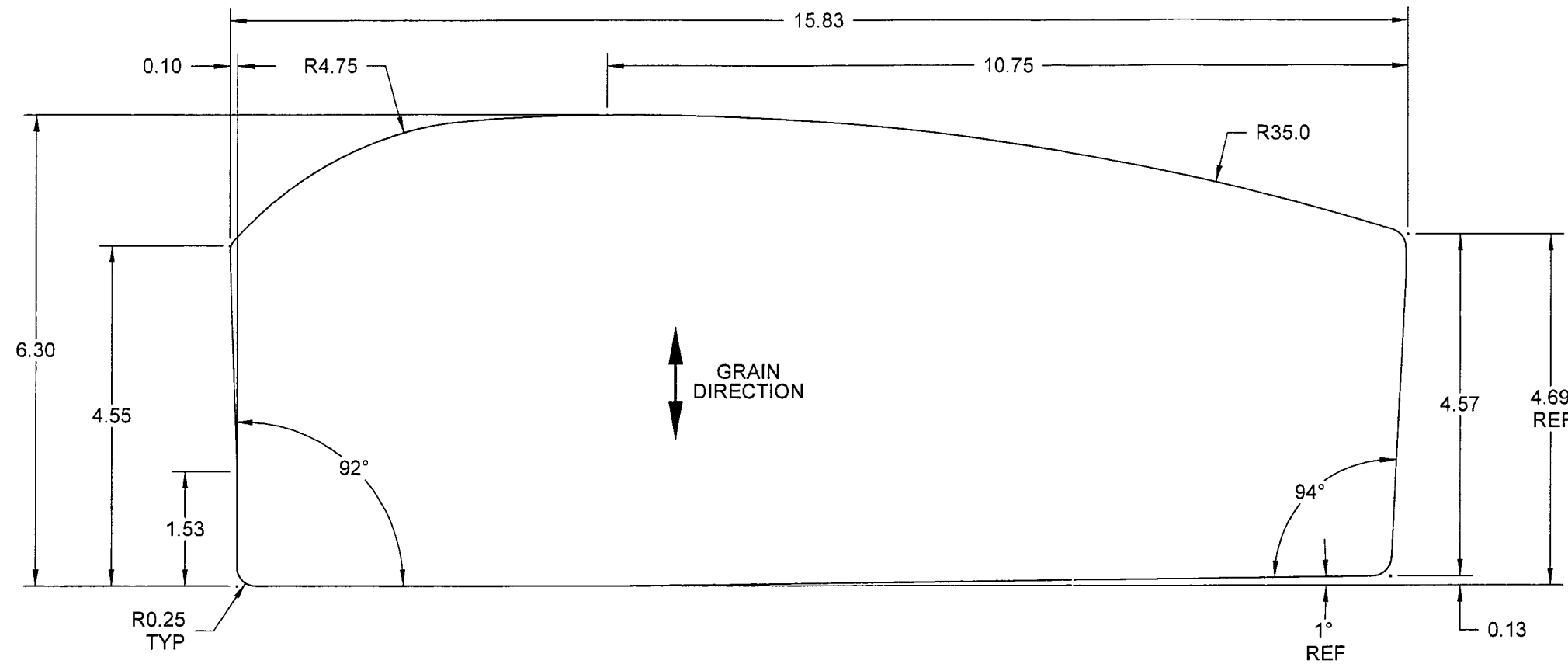
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3703-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3703-1 = 0.56 lbs
D3703-3 = 0.23 lbs
D3703-5 = 0.03 lbs
- 8) MANUFACTURE PART FROM "D3703-1F.DXF" FILE

PRELIMINARY ISSUE
12.18

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MFG. APPR.		D3703	SHEET 1 OF 4
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D3703-1F AFT DOUBLER FLAT PATTERN

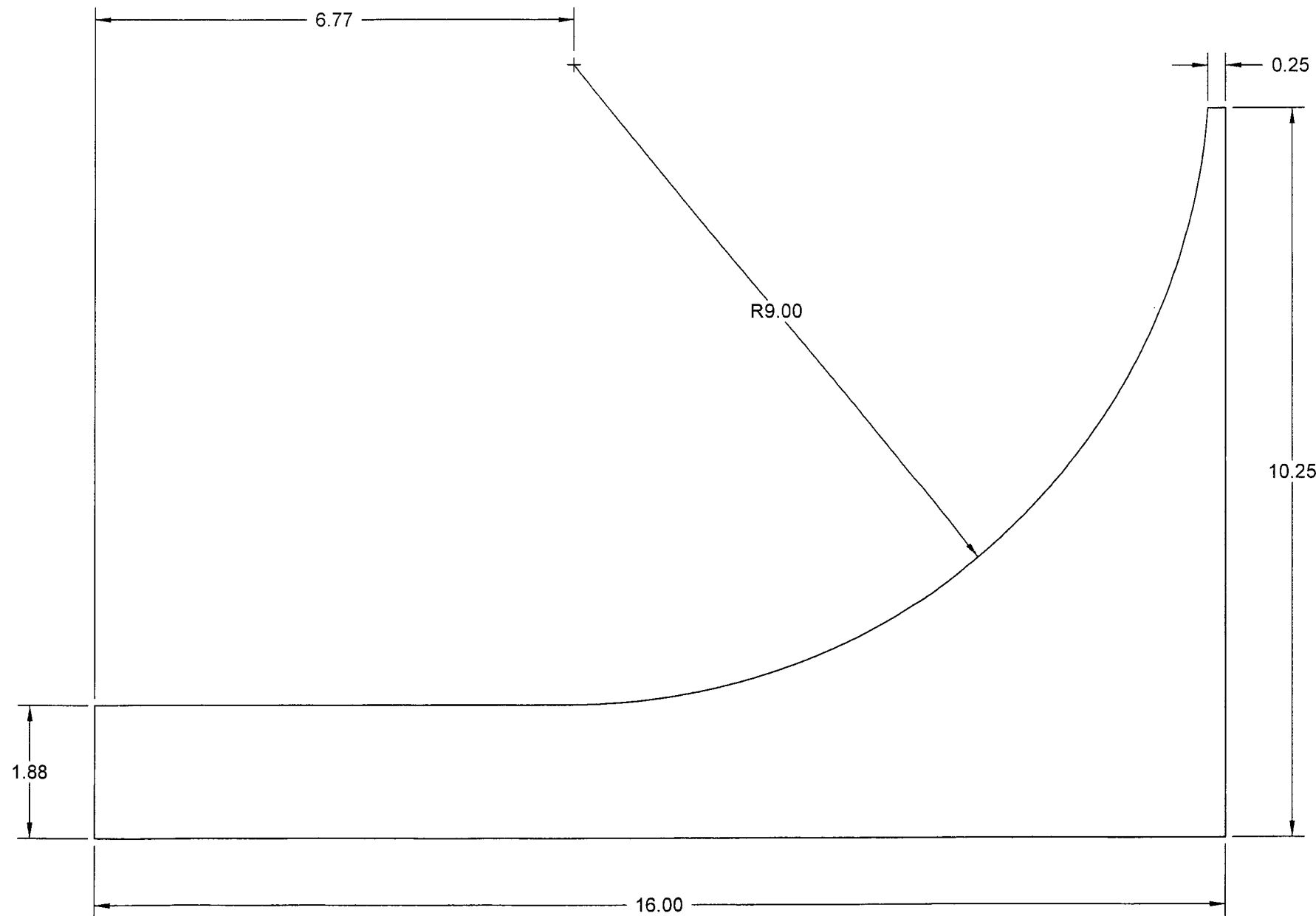
D3703-1 AFT DOUBLER
(MAKE FROM D3703-1F)

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2008.12.18

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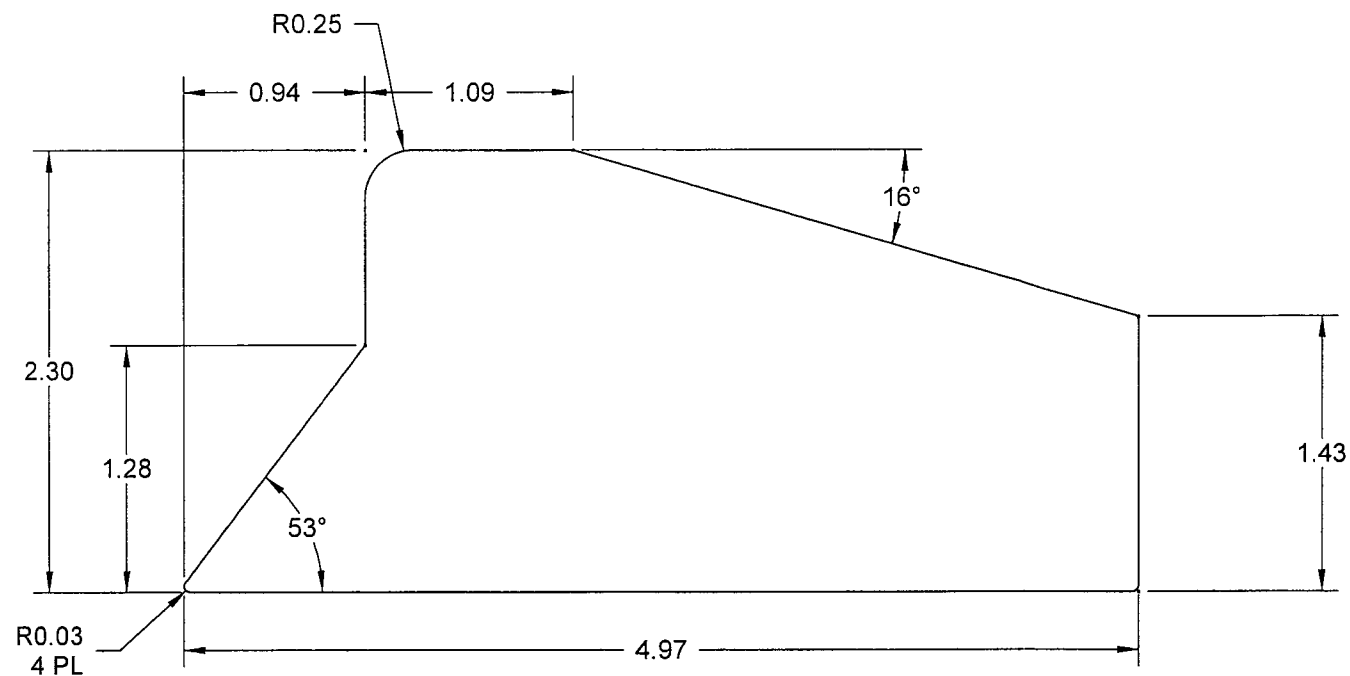


D3703-3 AFT CORNER DOUBLER

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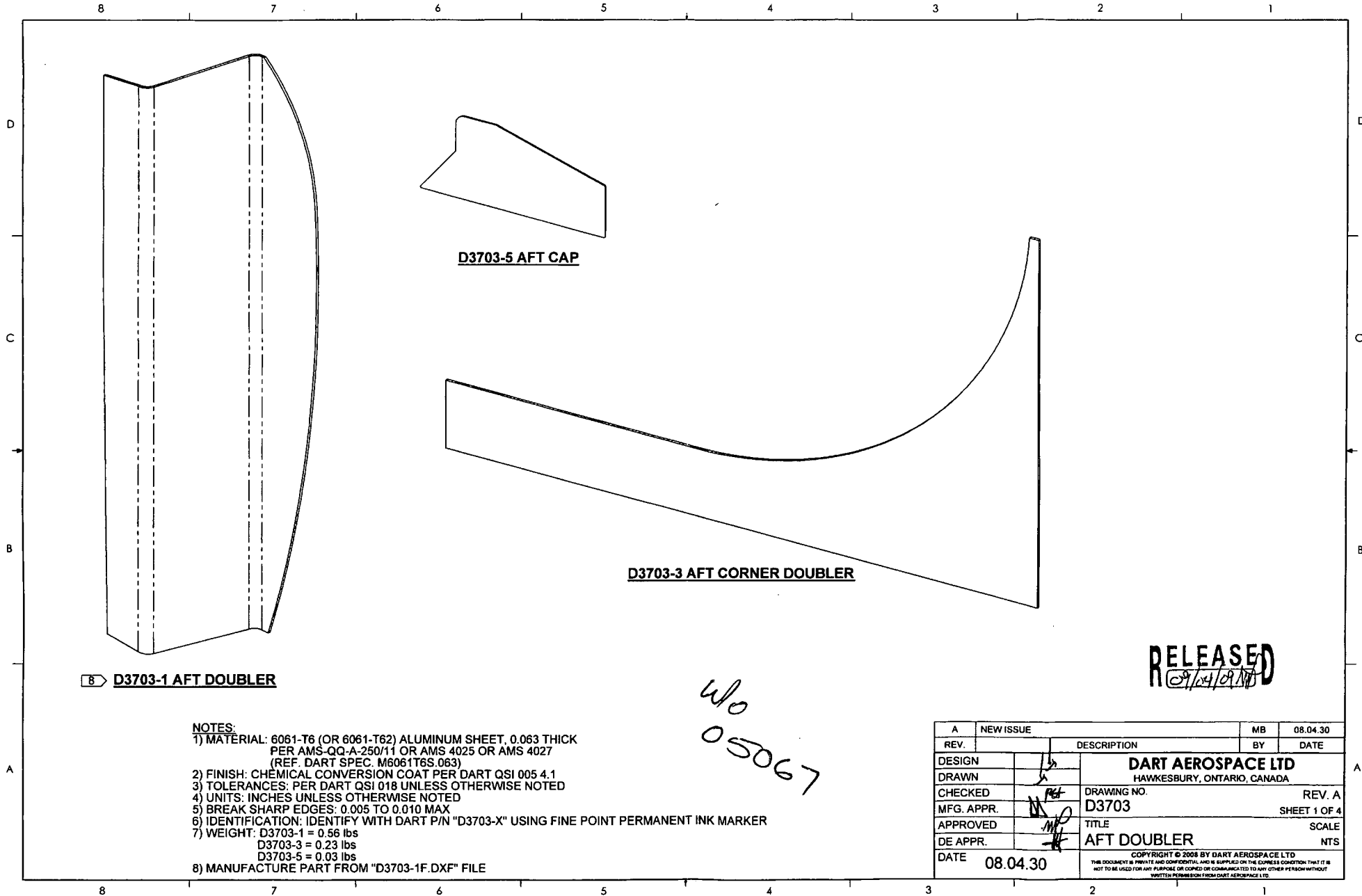
D3703-5 AFT CAP

PRELIMINARY ISSUE

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07/04/07

NOTES:

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- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3703-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3703-1 = 0.56 lbs
D3703-3 = 0.23 lbs
D3703-5 = 0.03 lbs
- 8) MANUFACTURE PART FROM "D3703-1F.DXF" FILE

A		NEW ISSUE		MB	08.04.30
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3703 TITLE AFT DOUBLER		REV. A	
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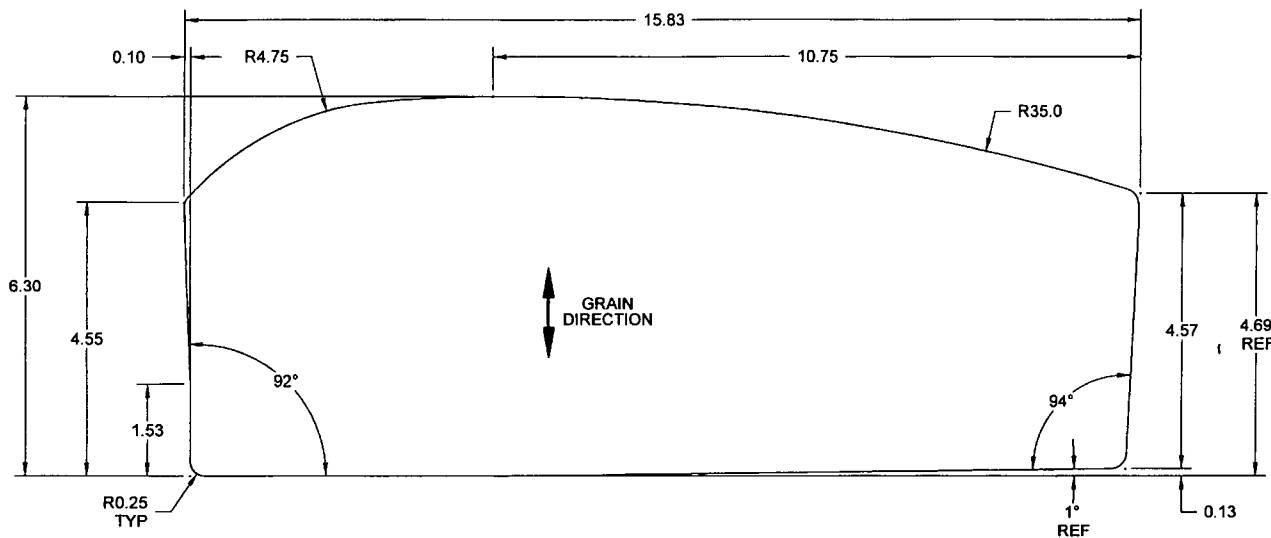
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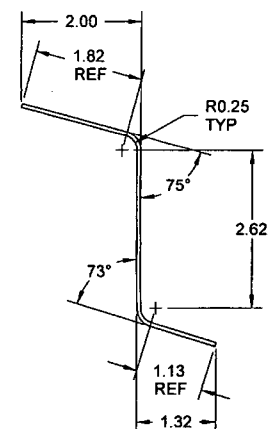
C

B

A



D3703-1F AFT DOUBLER FLAT PATTERN



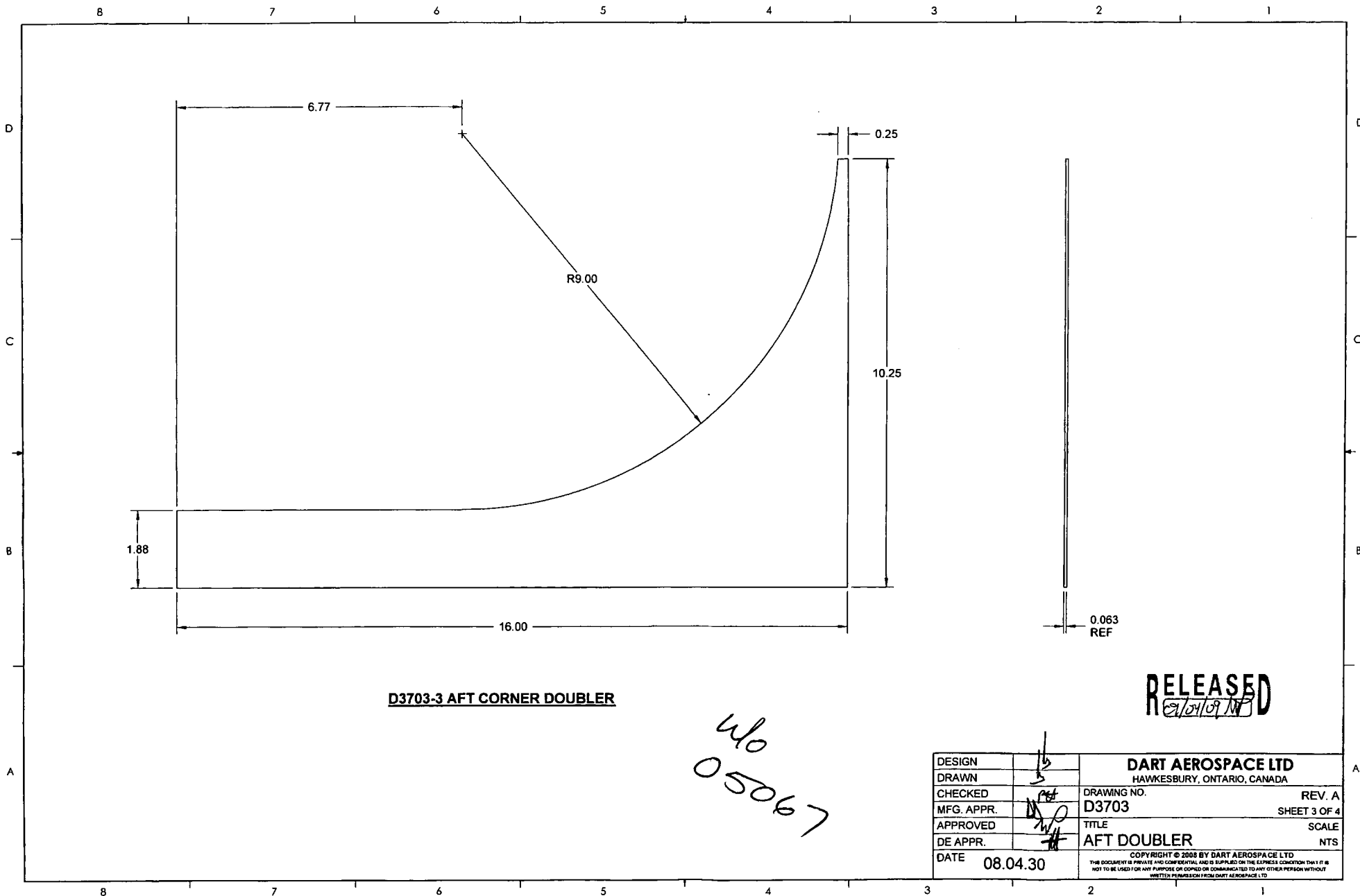
**D3703-1 AFT DOUBLER
(MAKE FROM D3703-1F)**

RELEASED
09/04/09

W/O
05067

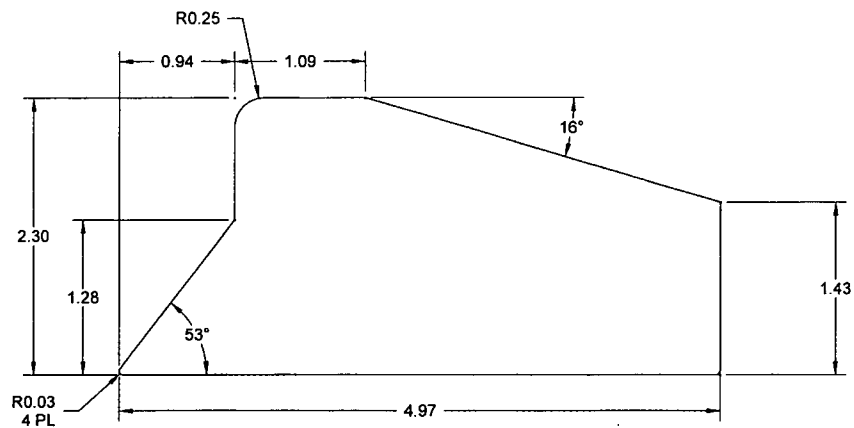
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8 7 6 5 4 3 2 1



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D3703-5 AFT CAP

460 05067

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09/04/09 NW

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